

Work Order ID 78728

January-13-12 7:10:19 AM

78728

Page 1

Item ID: D3140-97 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Doubler
Start Date: 12/01/2012 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 26/01/2012 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: M.L.J Date: 12/01/13 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3140	Rev F

100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3140 ***ENSURE THAT GRAIN DIRECTION IS CORRECT***** Dwg Rev: <u>F</u> Prog Rev: <u>F</u> 2-Deburr if necessary								
2024 .032									

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS 16 2/08/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00							
130									
Small Fab	Memo	0.00				4			12/08/20
Small Fab	1-Form as per Dwg D3140 2-Scuff surfaces with 80grit sandpaper per QSI 0063-Deburr. No sharp edges								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							(40)
Quality Control									
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.00				4	26	12-8-21	
Hand Finishing									

DAS
16
9-13

12/08/20

W/O:		WORK ORDER CHANGES					
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Required Date: 26/01/2012 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160						4	0	BR 12-8-21	
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>028</u>	0.00							
170						4x		SK 12/08/22	
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180								MCJ 12/08/23	
QC	Memo	0.00							
Quality Control									

W1208.22

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NOTE: Date & initial all entries

Picklist Print

January-13-12 7:10:24 AM

Page 1

Work Order ID: 78728

78728

Parent Item: D3140-97

D3140-97

Parent Item Name: Doubler

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP A02.04.30New IssueNG
IPP Rev B New dwg rev. ecn781 06.04.18 EC
IPP Rev:C Now on Waterjet 06-06-08 JLM
IPP rev.D added scuffing NCR 061 EC
IPP Rev:E As per ECN #829 06-11-20 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.032

Purchased

No

100

sf

106.7000

0.171

0.72

M2024T3S 032

**

0.75

2024-T3 .032 sheet

Jm 12-6-12

Location

Loc Qty

Loc Code

MAT022

106.7

118243

30.7

118523

76

121309

121309

W/O:		WORK ORDER CHANGES					
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DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED JH	DRAWING NO. D3140	REV. F SHEET 1 OF 7
DATE 06.10.06		TITLE DOOR	SCALE NTS
A	02.04.18	NEW ISSUE	
B	03.01.23	REMOVE -65/-81/-83; ADD -301/-303	
C	04.11.08	CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106°	
D	05.11.23	ADD -103/-104/-105/-106; REMOVE -67	
E	06.06.09	1.75 WAS 1.88, 4.75 WAS 4.13 ON -08/-07, 1.00 WAS 1.20 ON -09/-10	
F	06.10.06	ADD NOTE 14; CORRECT PART TITLE, NOW D3140-09/-92/-104 SHOWN D3140-10/-91/-103 OPPOSITE	

RELEASED

06.11.13

STANDARD

1.00

1.00

NOT TO BE COPIED

OR REPRODUCED

1.00

1.00

78728 M.L.S

12/01/13

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION
X						D3140-05	DOOR
	X					D3140-06	DOOR
		X				D3140-07	DOOR
			X			D3140-08	DOOR
		1		X		D3140-09	DOUBLER ASSEMBLY
			1		X	D3140-10	DOUBLER ASSEMBLY
3	3					D3140-57	PAD
1	1					D3140-59	PAD
2	2					D3140-61	PAD
2	2					D3140-63	PAD
		1	1			D3140-69	PAD
		1	1			D3140-71	PAD
		1	1			D3140-73	PAD
		1	1			D3140-75	PAD
		1	1			D3140-77	PAD
		1	1			D3140-79	PAD
				1	1	D3140-85	ANGLE
1	1					D3140-87	DOUBLER
				1	1	D3140-89	DOUBLER
		1				D3140-91	DOUBLER
			1			D3140-92	DOUBLER
3	3					D3140-95	DOUBLER
1						D3140-97	DOUBLER
	1					D3140-98	DOUBLER
		1	1			D3140-99	DOUBLER
		2	2			D3140-101	DOUBLER
		1				D3140-103	DOUBLER
			1			D3140-104	DOUBLER
		1				D3140-105	DOUBLER
			1			D3140-106	DOUBLER
1	1					D3140-241	DOUBLER
1		1				D3140-301	DOUBLER
	1		1			D3140-303	DOUBLER
				5	5	MS20426AD3-4	RIVET



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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED #	DRAWING NO. D3140	REV. F SHEET 2 OF 7
DATE 06.10.06		TITLE DOOR	SCALE NTS

1

COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM

2

FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S

3

MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

RELEASED

06.11.13

4

MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

5

MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

6

MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

7

MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECELL

8

ALL DIMENSIONS IN INCHES

9

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

10

MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

11

DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION

12

DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION

13

RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130

14

PARTS MUST BE SCUFFED WITH 80 GRIT SANDPAPER PRIOR TO ACID ETCH AND
ALODINE PER DART QSI 005 4.1



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0728

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Technical drawing of a ship's hull cross-section, showing structural details and dimensions. The drawing includes two main hull sections and a bottom view.

Dimensions and References:

- Overall width: 76.50 (REF)
- Overall length: 66.50 ±0.25
- Top edge dimensions: 44.55 ±0.25, 21.30 ±0.25, 7.60 REF, 7.00 REF
- Internal width dimensions: 30.00 REF, 4.00 REF, 30.00 REF
- Internal height dimensions: 28.40 2 PL REF, 23.525 2 PL REF, 5.60 (REF), 6.50 REF, 25.00 REF, 34.00 REF, 19.00 REF, 6.00 REF, 1.50
- Radius: R4.20 (8 PLACES, REF), R5.00 (8 PLACES, REF)
- Material specifications: D3140-97 (-05) or D3140-98 (-06) BONDED TO DOOR E761/7781 OVER LAPPING 1.00"±0.25 ALL AROUND 2 PLY; D3140-95 (3 PLACES) BONDED TO DOOR E761/7781 OVER LAPPING 1.00"±0.25 ALL AROUND 2 PLY; D3140-61 (2 PLACES); D3140-87 BONDED INTO DOOR; D3140-59 (REF); D3140-61 (REF); D3140-63 (REF)
- Other labels: D3140-241, D3140-97 (-05), D3140-98 (-06), E761/7781, 1.00"±0.25, ALL AROUND 2 PLY, D3140-95 (3 PLACES), BONDED TO DOOR E761/7781 OVER LAPPING 1.00"±0.25 ALL AROUND 2 PLY, D3140-61 (2 PLACES), 7.60 REF, 7.00 REF, 21.30 ±0.25, 44.55 ±0.25, 30.00 REF, 4.00 REF, 30.00 REF, 28.40 2 PL REF, 23.525 2 PL REF, 5.60 (REF), R4.20 (8 PLACES, REF), R5.00 (8 PLACES, REF), D3140-87 BONDED INTO DOOR, D3140-59 (REF), D3140-61 (REF), D3140-63 (REF), 6.50 REF, 25.00 REF, 34.00 REF, 19.00 REF, 6.00 REF, 1.50, D3140-241, D3140-97 (-05), D3140-98 (-06), E761/7781, 1.00"±0.25, ALL AROUND 2 PLY

RELEASED

06.11.13

TAPER A/R AS SHOWN
PER TOOL # B30-23000-57T
(2 PLACES)

1.00 REF

1.00 REF

D3140-63 (REF)

D3140-61 (REF)

D3140-63 (REF)

E761/7781
2 PLY
THRU OUT INNER SHELL

R0.50

D3140-59 (REF)

D3140-57
(3 PLACES)


FILL IN GAPS
& BOND PADS
MA560 FOAM
(A/R)

E761/7781
3 PLY
THRU OUT OUTER SHELL

SECTION B-B

ALL OUTER RADII
PER TOOL # B30-23000-01T/-02T

D3140-05 DOOR (SHOWN, REPLACES PREMIER P/N B30-23000-05)
D3140-06 DOOR (OPPOSITE, REPLACES PREMIER P/N B30-23000-06)
 (WINDOWS & CUTOUTS TO BE LOCATED PER B30-23000-01T/-02T TOOL)



Three triangles are shown, labeled 1, 2, and 3 from left to right.

DESIGN 4	DRAWN BY CB	DART	DART AEROSPACE LTD. HARRISBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3140	REV. F SHEET 3 OF 7
DATE 06.10.06	TITLE DOOR		SCALE NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

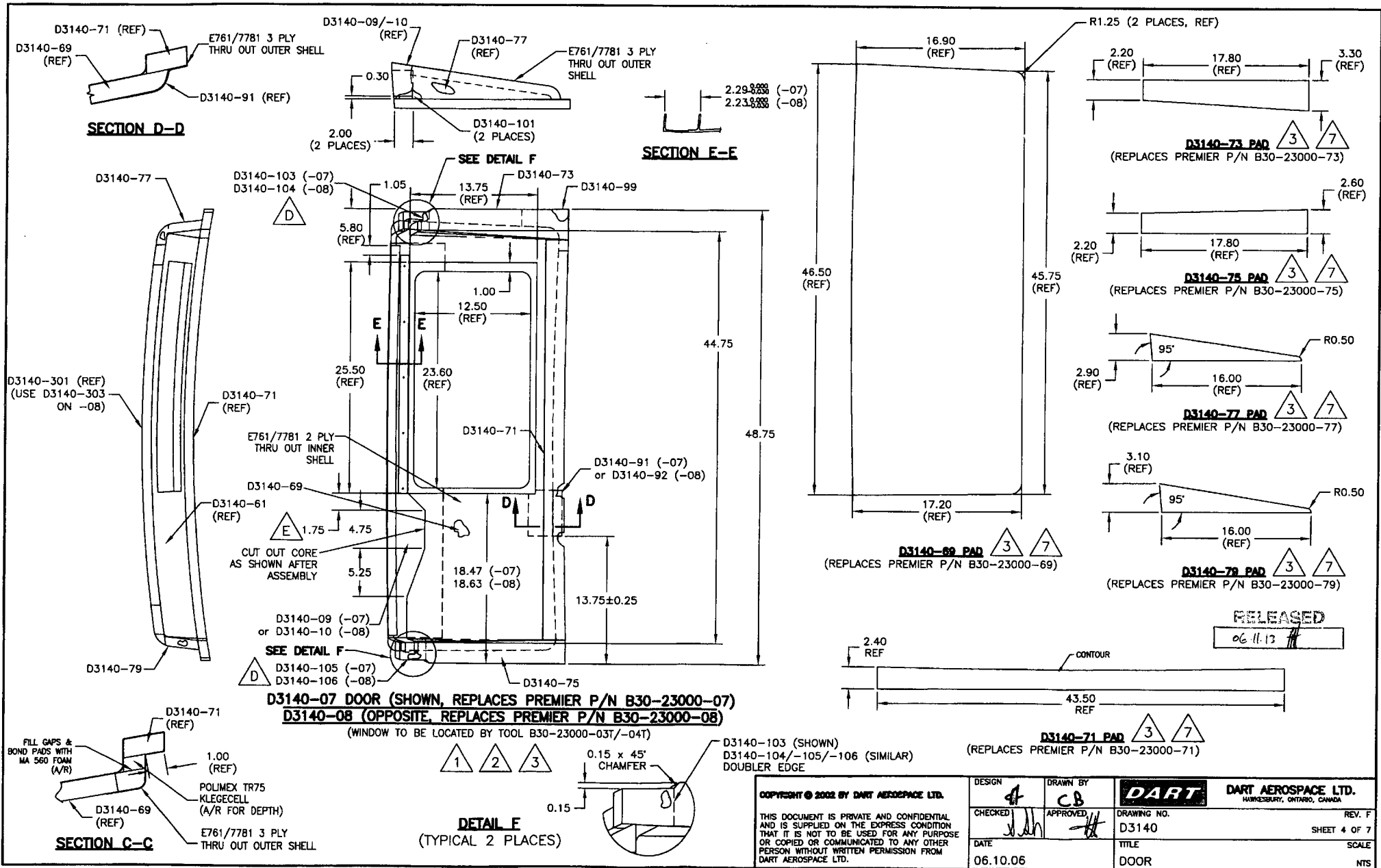
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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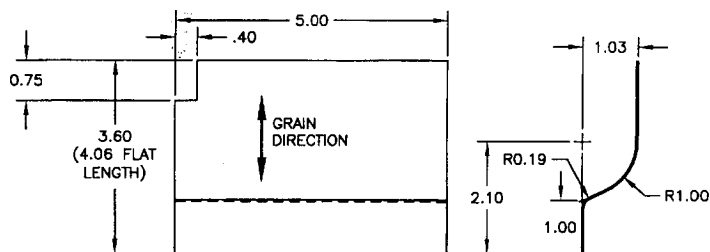
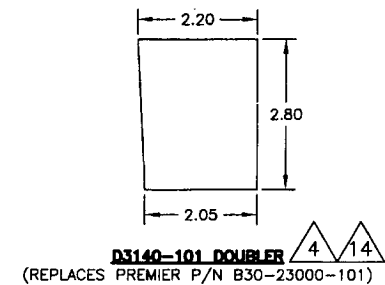
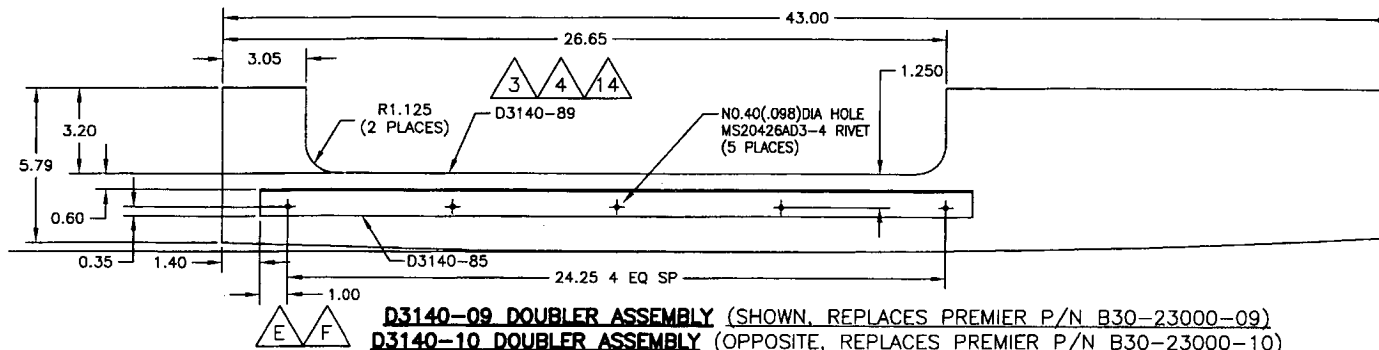
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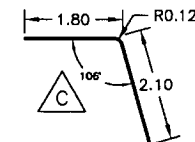
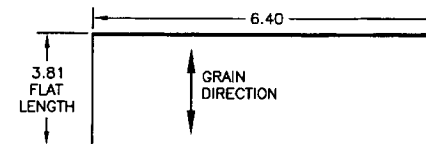
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7872



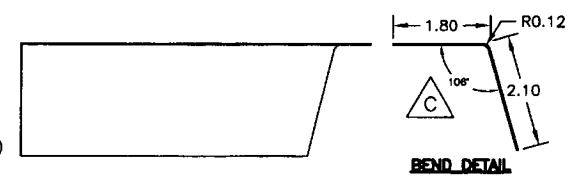
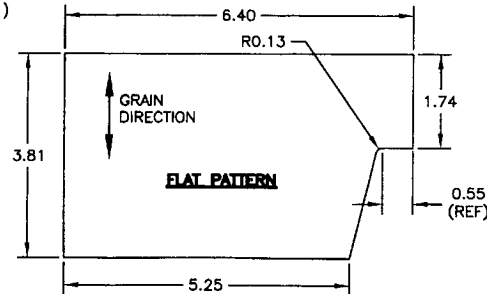
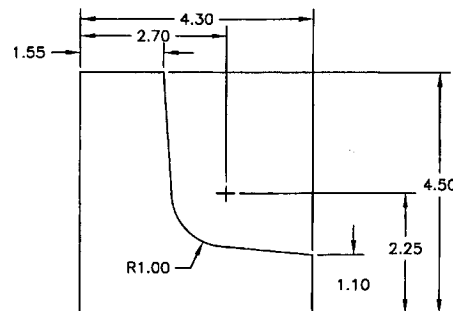
D3140-92 DOUBLER (SHOWN, REPLACES PREMIER P/N B30-23000-92)
D3140-91 DOUBLER (OPPOSITE, REPLACES PREMIER P/N B30-23000-91)



D3140-98 DOUBLER (OPPOSITE, REPLACES PREMIER P/N B30-23000-98)

RELEASED

06 11 13



D3140-98 DOUBLER (OPPOSITE, REPLACES PREMIER P/N B30-23000-98)

BEND DETAIL

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DESIGN #	DRAWN BY CB	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED JH	APPROVED JH	DRAWING NO. D3140	REV. F SHEET 5 OF 7
DATE 06.10.06	TITLE DOOR	SCALE NTS	

W/O:		WORK ORDER CHANGES					
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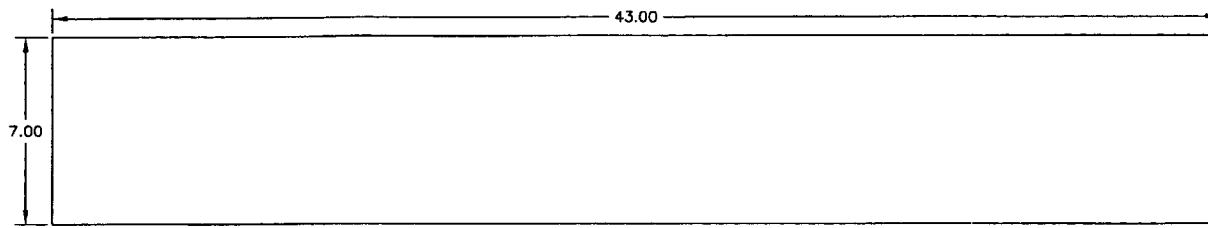
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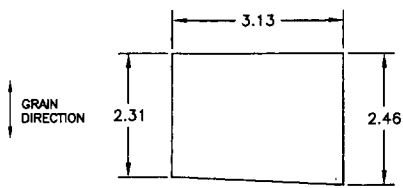
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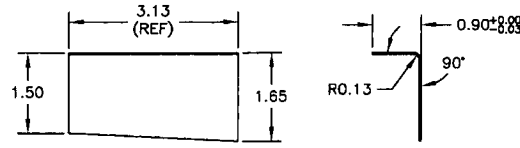
78720



D3140-87 DOUBLER $\triangle 4 \triangle 14$
(REPLACES PREMIER P/N B30-23000-87)

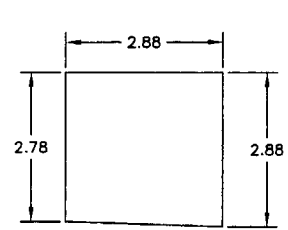


D3140-105F FLAT PATTERN
(USED TO MAKE D3140-105/-106 BRACKETS)

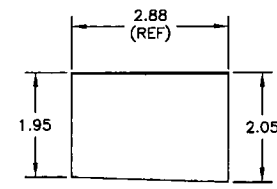


D3140-105 DOUBLER
D3140-106 OPPOSITE

$\triangle 4 \triangle 14 \triangle D$

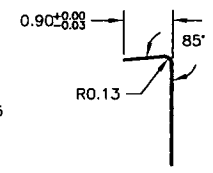


D3140-103F FLAT PATTERN
(USED TO MAKE D3140-103/-104 BRACKETS)

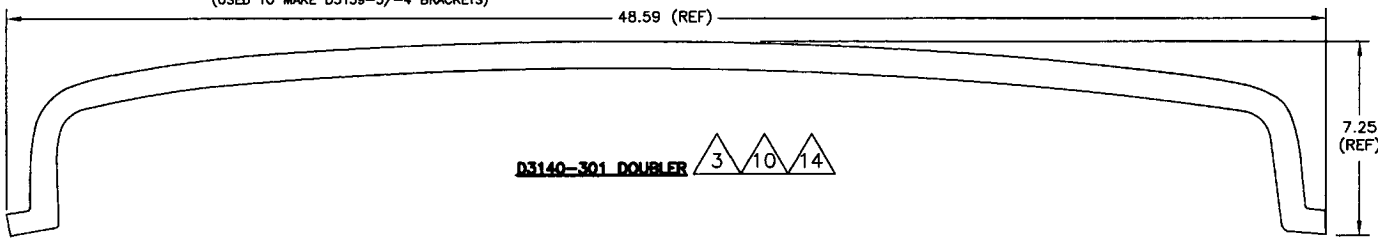


D3140-104 DOUBLER
D3140-103 OPPOSITE

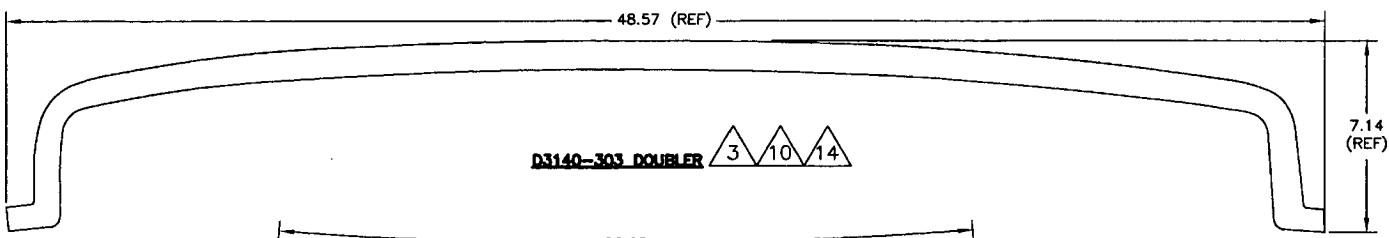
$\triangle 4 \triangle 14 \triangle D \triangle F$



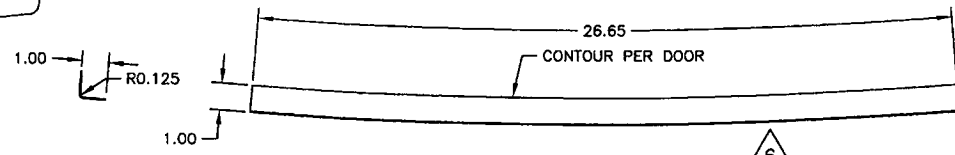
D3159-3F FLAT PATTERN
(USED TO MAKE D3159-3/-4 BRACKETS)



D3140-301 DOUBLER $\triangle 3 \triangle 10 \triangle 14$



D3140-303 DOUBLER $\triangle 3 \triangle 10 \triangle 14$



D3140-85 ANGLE $\triangle 6$
FLAT PATTERN: 26.65" x 1.90"
(REPLACES PREMIER P/N B30-23000-85)

RELEASED
06.11.13

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DATE 06.10.06		TITLE DOOR		SCALE NTS	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

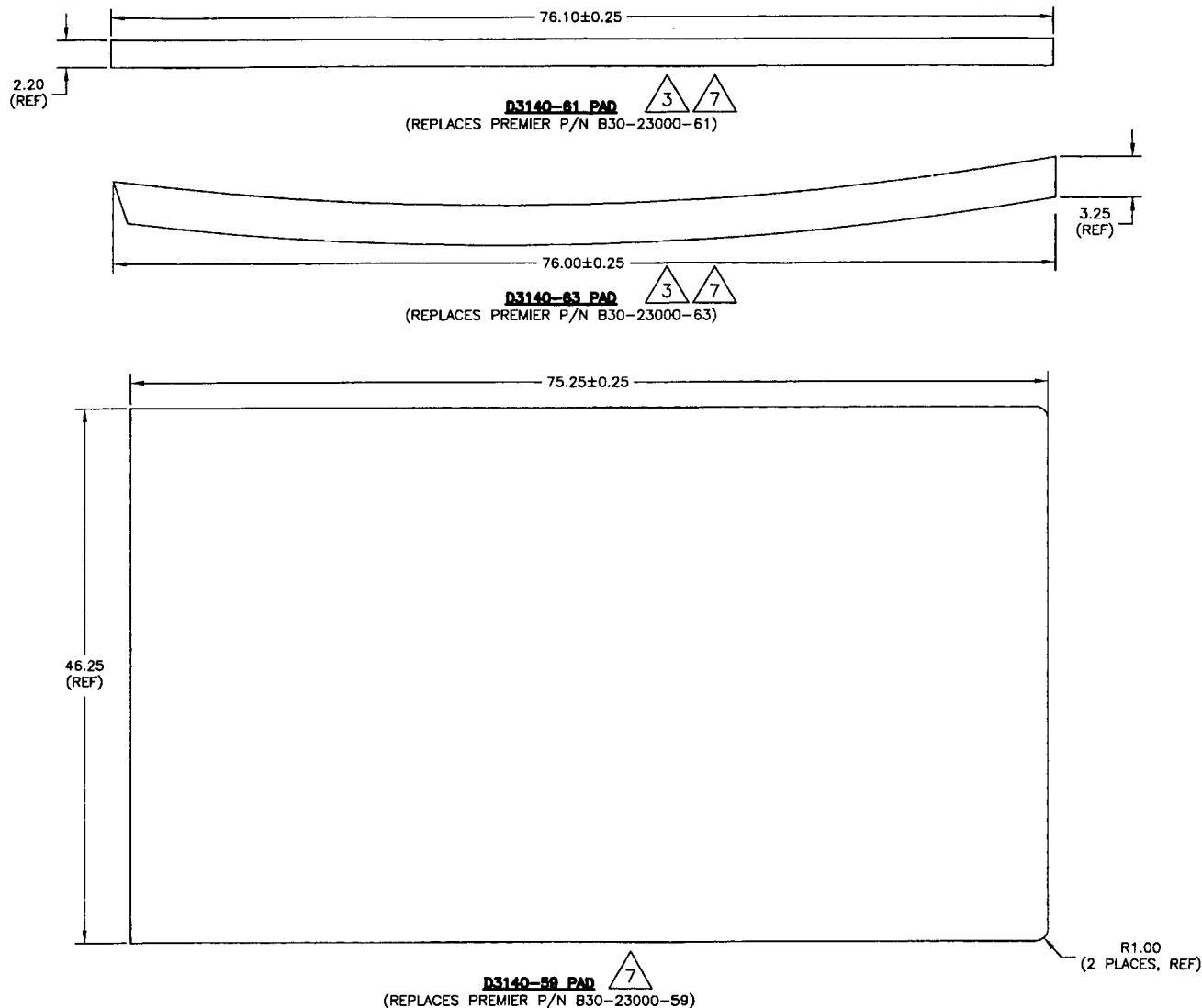
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78720



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CHECKED Jdh	APPROVED	DRAWING NO. D3140	REV. F SHEET 7 OF 7
DATE 06.10.06		TITLE DOOR	SCALE NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries